

Listing of Claims:

This listing of claims reflects all claim amendments and replaces all prior versions, and listings, of claims in the application. Material to be inserted is in underline, and material to be deleted is in ~~strikeout~~ or (if the deletion is of five or fewer consecutive characters or would be difficult to see) in double brackets [[]]. Any cancellations are without prejudice.

1-21. (canceled)

22. (new) A method for injecting an injection molded part made of plastic, using an injection unit having a gate in a nozzle housing, the gate being connected to a flow channel which opens into a filling space in which an outer needle, and within same an inner needle for closing the gate, are guided, the outer needle first being pulled back, thereby forming a filling space, and plastic is drawn in from the flow channel and the filling space is predosed with plastic from the flow channel, during which the inner needle holds the gate closed, and at the end or after predosing, the gate is opened by lifting the inner needle, and the predosed plastic material is pressed through the gate into a cavity by a lifting motion of the outer needle, the volume of plastic inside the filling space being essentially zero at the end of the injection process or of the application of retention pressure, and the inner needle closes the gate at the end of the lifting motion of the outer needle or at the end of a predetermined retention time.

23. (new) The method according to Claim 22, wherein the base of the filling space runs at an angle toward the gate, and the tip of the outer needle has a corresponding design.

24. (new) The method according to Claim 22, wherein the flow channel opens into the filling space, near the base thereof.

25. (new) The method according to Claim 22, wherein the lifting motion of the inner and/or outer needle is produced by mechanical, hydraulic, or electrical means.

26. (new) The method according to Claim 22, wherein additional plastic material is introduced into the cavity, also to compensate for any shrinkage, by at least one further lifting motion of the outer needle.

27. (new) The method according to Claim 22, wherein additional plastic material is introduced into the filling space through at least one second, blockable flow channel.

28. (new) The method according to Claim 27, wherein the inner needle is pulled back and a flow channel is opened, via which melt is introduced directly into the cavity through the gate, while the inner needle continues to block the filling space.

29. (new) The method according to Claim 28, wherein the inner needle is pulled back further, and the passage from the filling space to the cavity is opened.

30. (new) A device for injecting an injection molded part made of plastic, having a gate in a nozzle housing, the gate being connected to a flow channel, and an inner needle is provided in the gate in the nozzle housing, and an outer needle is provided for dosing, pressing, and optionally applying pressure to the melt, the flow channel opening into a filling space in which the outer needle is also guided, wherein the flow channel opens into the filling space, at the base thereof.

31. (new) The device according to Claim 30, wherein the base of the filling space runs at an angle toward the gate, and the tip of the outer needle has a corresponding design.

32. (new) The device according to Claim 30, wherein a blocking element is provided in the flow channel.

33. (new) The device according to Claim 30, wherein at least one additional flow channel opens into the filling space and is likewise provided with a blocking element.

34. (new) The device according to Claim 33, wherein the flow channel discharges a short distance below the gate, while the flow channel opens into the filling space, near the base thereof.

35. (new) The device according to Claim 30, wherein the nozzle housing forms an injection unit with the two needles and the flow channel(s), and the injection unit may be associated with a cavity.

36. (new) A method for injecting an injection molded part made of plastic using an injection unit, the injection unit comprising a nozzle housing, a gate contained within the nozzle housing, a filling space, a flow channel in communication with the filling space for introducing plastic into the filling space, an outer needle movable to change a volume of the filling space, and an inner needle movable to control flow of plastic through the gate, the method comprising:

moving the outer needle a first direction to draw plastic into the filling space from the flow channel while preventing the flow of plastic through the gate with the inner needle;

moving the inner needle to open the gate; and

moving the outer needle a second direction to move plastic through the gate.